

HiFill FR® PA6 GF33 FR HS L RD190

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Red
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.64		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.65E+6	psi	ASTM D638
Tensile Strength (Yield)	19500	psi	ASTM D638
Tensile Elongation (Break)	1.9	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	470 to 490	°F
Middle Temperature	480 to 500	°F
Front Temperature	490 to 510	°F
Nozzle Temperature	500 to 520	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	105 to 175	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

